

Date: Wednesday, 3/8/2006 10:38:42 AM  
 User: Kim Johnston

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HEAT OUTLET DEFLECTOR
Job Number :	26127		
Estimate Number :	12154		
P.O. Number :	NIA	Part Number :	D34721
This Issue :	3/8/2006	S.O. No. :	NIA
Prsht Rev. :	NC	Drawing Number :	D3472 REV.A
First Issue :	NIA	Project Number :	NIA
Previous Run :	NIA	Drawing Revision :	A
	Type :	Material :	NIA
	PURCHASED PARTS	Due Date :	3/31/2006
Written By :	SEE COMMENT BELOW		Qty: 20 Um: Each
Checked & Approved By :	06/03/08		
Comment :	est rev. A 06/02/02 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 00000768

Email or Ship DXF file to vendor

Make as per Dwg D3472 flat pattern D3472-1F

Material release note required

2.0	D34721F	FLAP FLAT PATTERN
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Comment: Qty.: 1.0000 (s)/Unit Total: 12.0000 (s)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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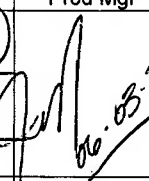
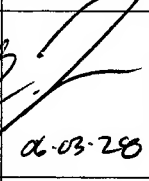
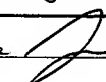



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Deburr

2-Bend as per dwg D3472

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-28	5.1	Acid etch and Alodine as per QSI 005 4.1	PL	06/03/28	(20)	 06-03-28	 06-03-28
		Buff out any marks on mat'l due to benching as per QSI 018					
		Permanence change  ADD to I.P.R.					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/03/30  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 26127

Part Number: D34721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-28 (20)

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/29 (20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/03/30 (20)

Job Completion



u 06.03.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

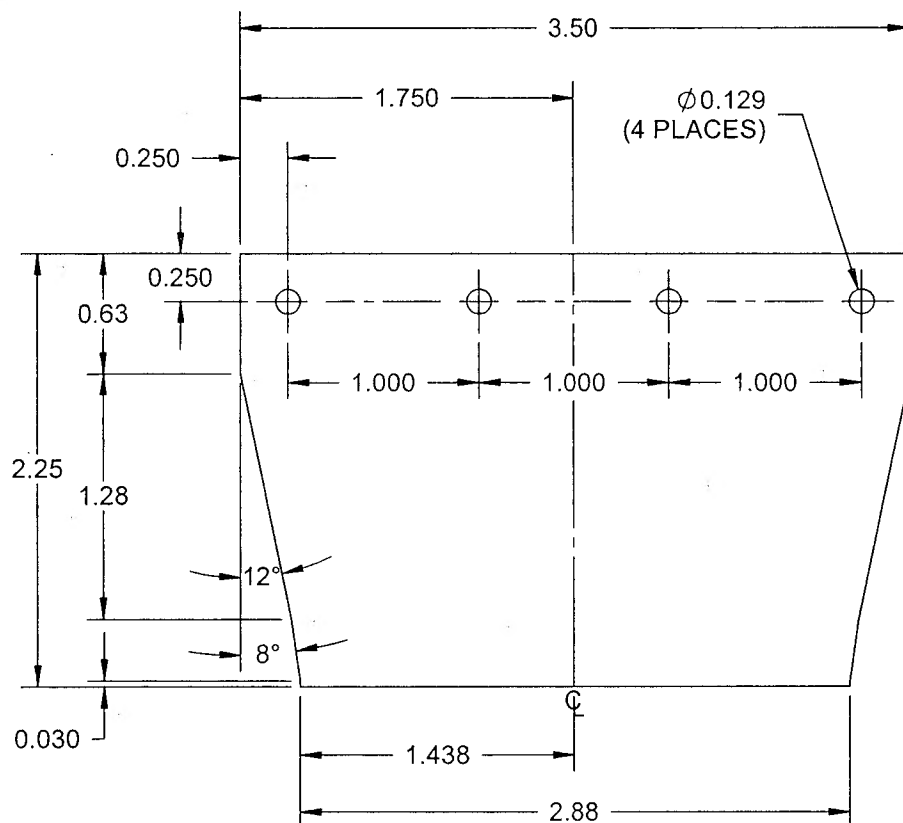
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

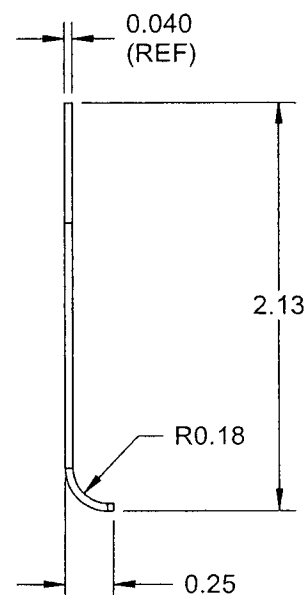
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3472	REV. A SHEET 2 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1



**D3472-1F FLAP FLAT PATTERN**



**D3472-1 FLAP  
BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



FAX 1 847 585 2500

CORUS ALUMINIUM

Corus Aluminium Walzprodukte G. m. b. H.  
 Postfach 100331 D-56033 Koblenz



# INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 2 / 03  
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO  
 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83418  
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+GQ2S0/5  
 CUSTOMER PART NO.:  
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA  
 QUANTITY: 344 DIMENSIONS: 0.040 x 48.00 x 144.00 INS

## Other tests:

Dimensional check:  
 Surface control:

OK  
 OK

## Normative references:

BESTELLNORM/SPECIFICATION/NORME  
 AMS 4041P+ASTM B 209-04+AMS-QQ-A-250/5A SEP1998

## Bend test:

L-direction

LT-direction OK

ST-direction

18 G. 1  
Koblenz



corus

CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE  
PAGE: 3 / 03

SERIAL-NO.:  
CORUS ALUMINIUM ROLLED  
PRODUCTS USA-A DIVIS  
CHAUMBURG, IL 60173  
ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO  
ORDER NO. MAN.: 83415  
SPEC.:  
AMS4041+B209+Q0250/5  
CUSTOMER PART NO.:

THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN  
TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL  
WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

DES:

INZ, the 25.08.03 SW

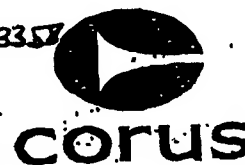
G. Mattler  
Quality Assurance  
Corus Aluminium  
Walzprodukte GmbH  
Koblenz

FROM: MAR-23-2006 04:24

TO: 6049464153



Corus Aluminium Walzprodukte G.m.b.H.  
Postfach 100331 D-56033 Koblenz



INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.:  
PURCHASER: CORUS ALUMINIUM ROLLED  
PRODUCTS USA-A DIVIS  
SCHAUMBURG, IL 60173  
ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230  
QUANTITY: 344 DIMENSIONS: 0.040 X 48.00 X 144.00 INS  
ORDER NO. PURCH.: US-AIRCR.DEPOT-PRO  
ORDER NO. MAN.: 83415  
SPEC.: AMS4041+B209+QQ250/5  
PAGE: 1 / 03  
CUSTOMER PART NO.:  
PRODUCT: PLA

RESULTS:

Mechanical properties:

Spec. No.	Y.S.	U.T.S.	El.
	KSI	KSI	%
Min. LT:	39,0	59,0	15,0
Max. LT:			
001	40,6	59,6	17,9
002	40,6	59,8	18,7
003	40,8	59,8	17,7
004	40,8	59,6	18,1

Chemical composition: in % , remainder Al

ALLOY:	ALLOY CORE	ALLOY LINER	ALLOY LINER
CAST-NO.	2024	1230 4	1230 4
	5-08-2914	142166-1	142166-1
Si	0,028	0,12	0,12
Fe	0,123	0,26	0,26
Cu	4,326	0,002	0,002
Mn	0,634	0,010	0,010
Mg	1,436	0,003	0,003
Cr	0,001	0,001	0,001
Zn	0,011	0,005	0,005
Ti	0,0278	0,019	0,019
B	0,0006	0,002	0,002
Zr	0,0006		
Pb	0,0016	0,0011	0,0011
Ni	0,0059		